

Date: Thursday, 2/14/2008 11:01:38 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	JACK SADDLE		
Job Number	37445			Part Number	D2281		
Estimate Number	11177			Drawing Number	D2281 REV G		
P.O. Number	:			Project Number	N/A		
This Issue	2/14/2008	S.O. No.	:	Drawing Revision	G		
Prsht Rev.	NC			Material	:		
First Issue	11	Type	SMALL /MED FAB	Due Date	3/20/2008	Qty:	100
Previous Run	36824			Um:	Each		
Written By	<u>1080214</u>						
Checked & Approved By							
Comment	Est Rev: A	Removed from 9 Digit	05-12-02	JLM			
	Est: rev B	06.07.17	waterjet EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S14GA	304SS .080
Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s) 304SS .080 batch: <u>107244</u> <u>IB 8-2-26</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: <u>G</u> <u>IB 8-2-26</u> Prog Rev: <u>G</u>		
2-Deburr if necessary <u>IB 8-2-26</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>IB 8-2-26</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>10802-27</u> <u>Counted</u>		
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<u>N/A</u>		
Comment: Deburr		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/03/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:  
User:

Thursday, 2/14/2008 11:01:38 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 37445

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 08/03/07 110

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/07 110 counts

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *108/3/10*

*sylvia* (110)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



110

Comment: FINAL INSPECTION/W/O RELEASE

08/03/07 111

Job Completion



*2008/3/10* 110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37445
Description: Jack Saddle	Part Number:	D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>HR</u>	Audited by: <u>  </u>	Prototype Approval: N/A
Date: 8-2-26	Date: 08.27	Date: N/A

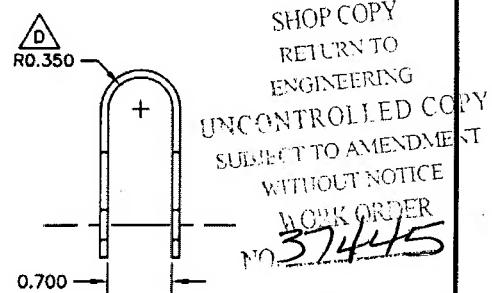
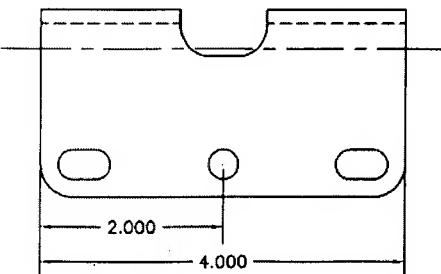
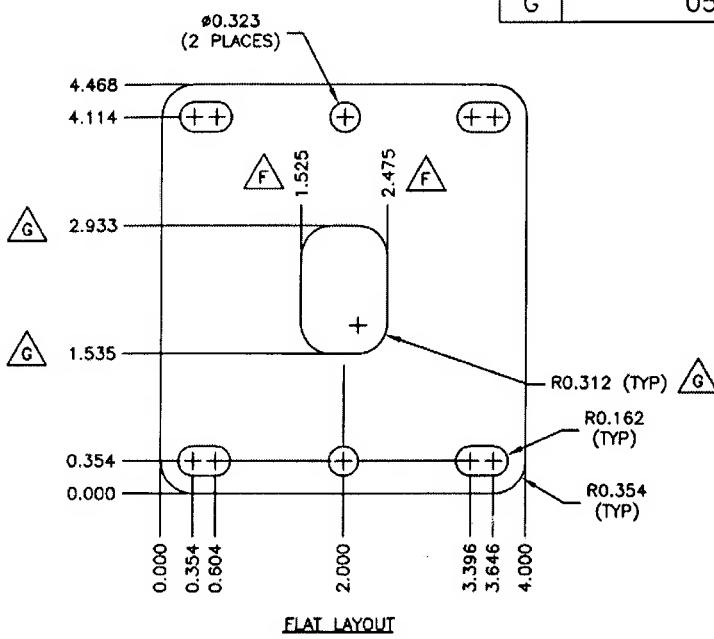
Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	JLM



**DART**

DESIGN BW	DRAWN BY <i>PS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>WMS</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

**RELEASED**  
*PS*  
05/08/11



#### D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED